

Ship ASAP - Door only for Carrie@DHS 11-0309

# Work Order ID 67137



Wednesday, March 09, 2011 10:46:27 AM

Page 1

Item ID: D3186-4

Accept



Setup Start



Revision ID:

Item Name: Spacepod Door, RH

Stop



Start Date: 3/9/2011 Start Qty: 1.00



Cust Item ID:

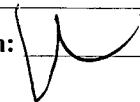
Required Date: 3/10/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:



Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3186

Rev E

100



Small Fab

Small Fab

Memo

N/A cust. wants door only

0.00

u

11-03-09  
per 2nd sched  
asmt



110



QC5- Inspect part completeness to step on W/O

0.00

QC

Quality Control

Memo

0.00

11-03-09

(no holes, slots)



120



Identify as per dwg & Stock Location:

0.00

Packaging

Packaging

Memo

0.00

11-03-09 C

W/O: 67137		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11-03-09	100	do not drill holes <del>for hinges</del> or cut out <del>holes</del> slots as per attached email, customer will do so as per their Specifed	BT	11-03-09	1		

Part No: D3186-4 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 67137**

Page 2

Wednesday, March 09, 2011 10:46:27 AM

Item ID:	D3186-4	Accept		Setup	Start				
Revision ID:									
Item Name:	Spacepod Door, RH								
Start Date:	3/9/2011	Start Qty:	1.00		Cust Item ID:				
Required Date:	3/10/2011	Req'd Qty:	1.00		Customer:				
Reference:							Run	Start	
Approvals:	Process Plan:	Date:	Tooling:	Date:			Stop		
	QC:	Date:	SPC (Y/N):	Date:					

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 	QC21- Final Inspection - Work Order Release	0.00						11/03/9	
QC	Memo	0.00							CD 1110 3/09

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, March 09, 2011 10:46:24 AM

Page 1

Work Order ID: 67137



Parent Item: D3186-4



Parent Item Name: Spacepod Door, RH

Start Date: 3/9/2011

Required Date: 3/10/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A New Issue 07-01-11 EC

IPP rev.B revD 07.03.07 ec

10-08-11 added trim door before drilling DD verf:EC

IPP Rev:C

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3186-2M  SPACEPOD DOOR RH		Manufactured	No			100	Each	1.0000	1	1		BT 11-03-09	

Location	Loc Qty	Loc Code
CA	1	
45693A	1	X1

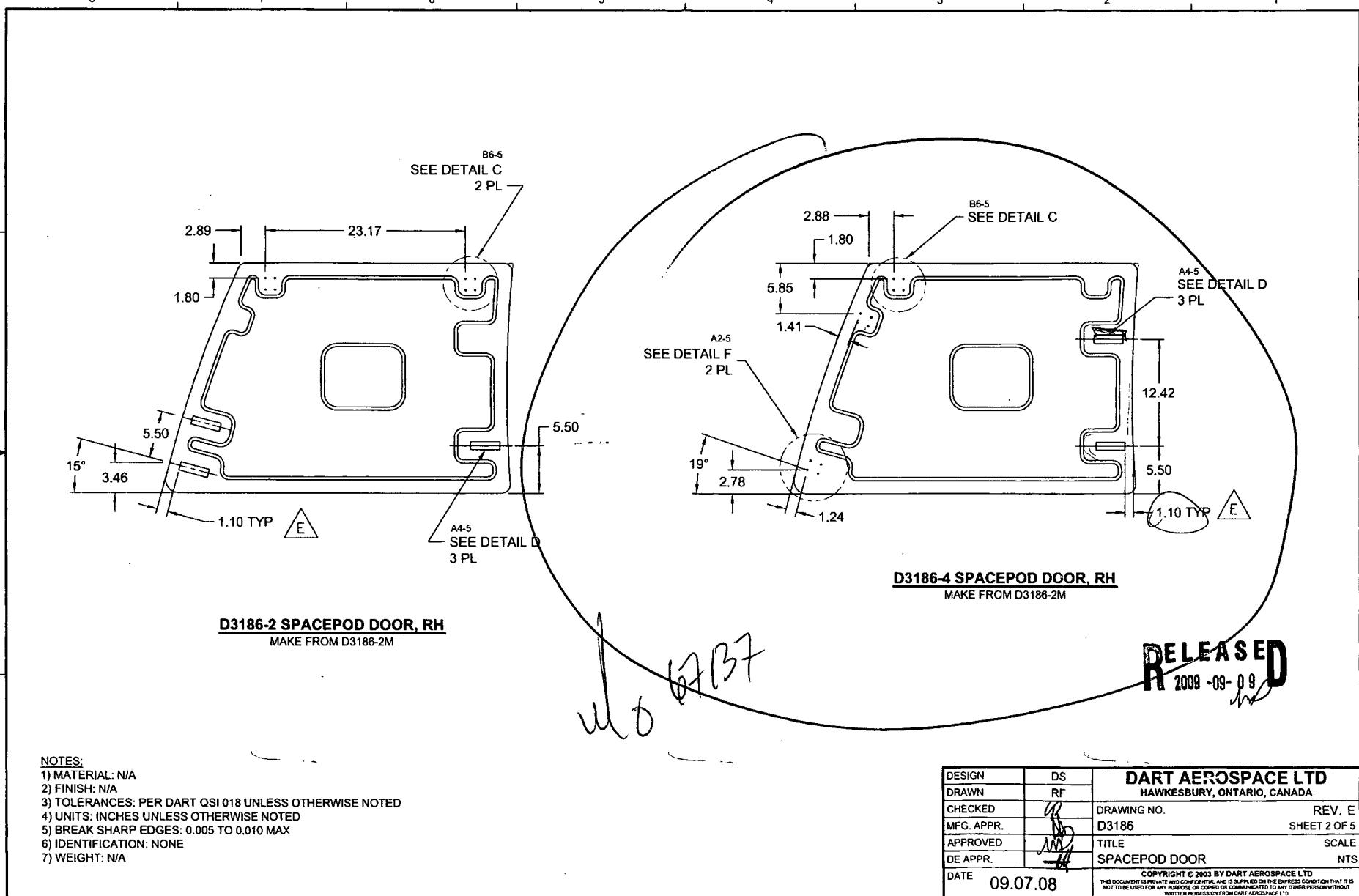
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



8 7 6 5 4 3 2 1

D

D

C

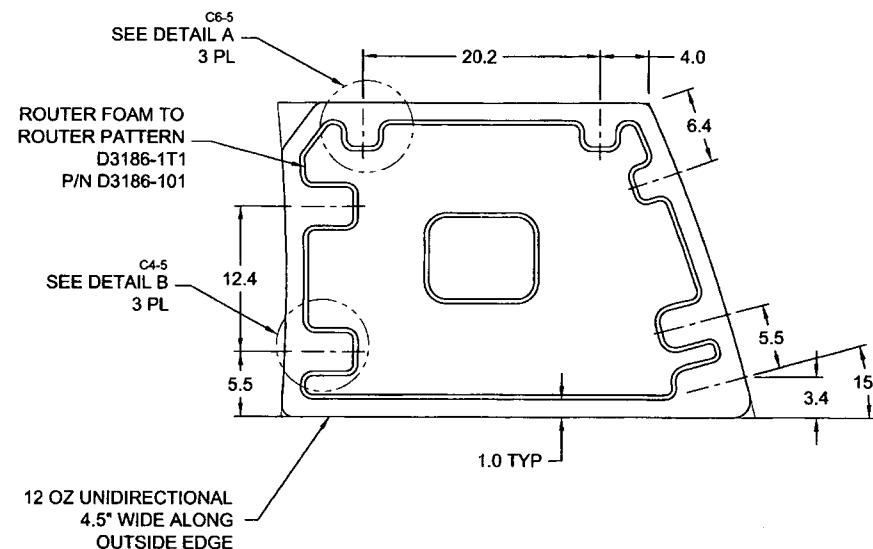
C

B

B

A

A

D3186-1M SPACEPOD DOOR AS MOLDED

## NOTES:

## 1) MATERIAL:

RESIN = EPOCAST 50-A/9816 OR DERAKANE 470-36/411/510A40  
 FOAM = 3/8", A500 CORE-CELL OR DIVINYCELL OR AIREX OR KLEGECCELL  
 FIBRE = 9.7 OZ 7781 WEAVE "S" GLASS ("9 OZ SATIN")  
 12 OZ UNIDIRECTIONAL FIBERGLASS ("12 OZ UNIDIRECTIONAL")  
 LAMINATE PER DART QSI 006 4.0  
 LAMINATION SCHEDULE PER THIS DRAWING

2) FINISH: FINISH INSIDE/OUTSIDE WITH DUPONT HIGBUILD GREY PRIMER 1144-S --  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 7.0 lbs  
 8) USE MOLD DT8005 FOR DOOR LAYUP

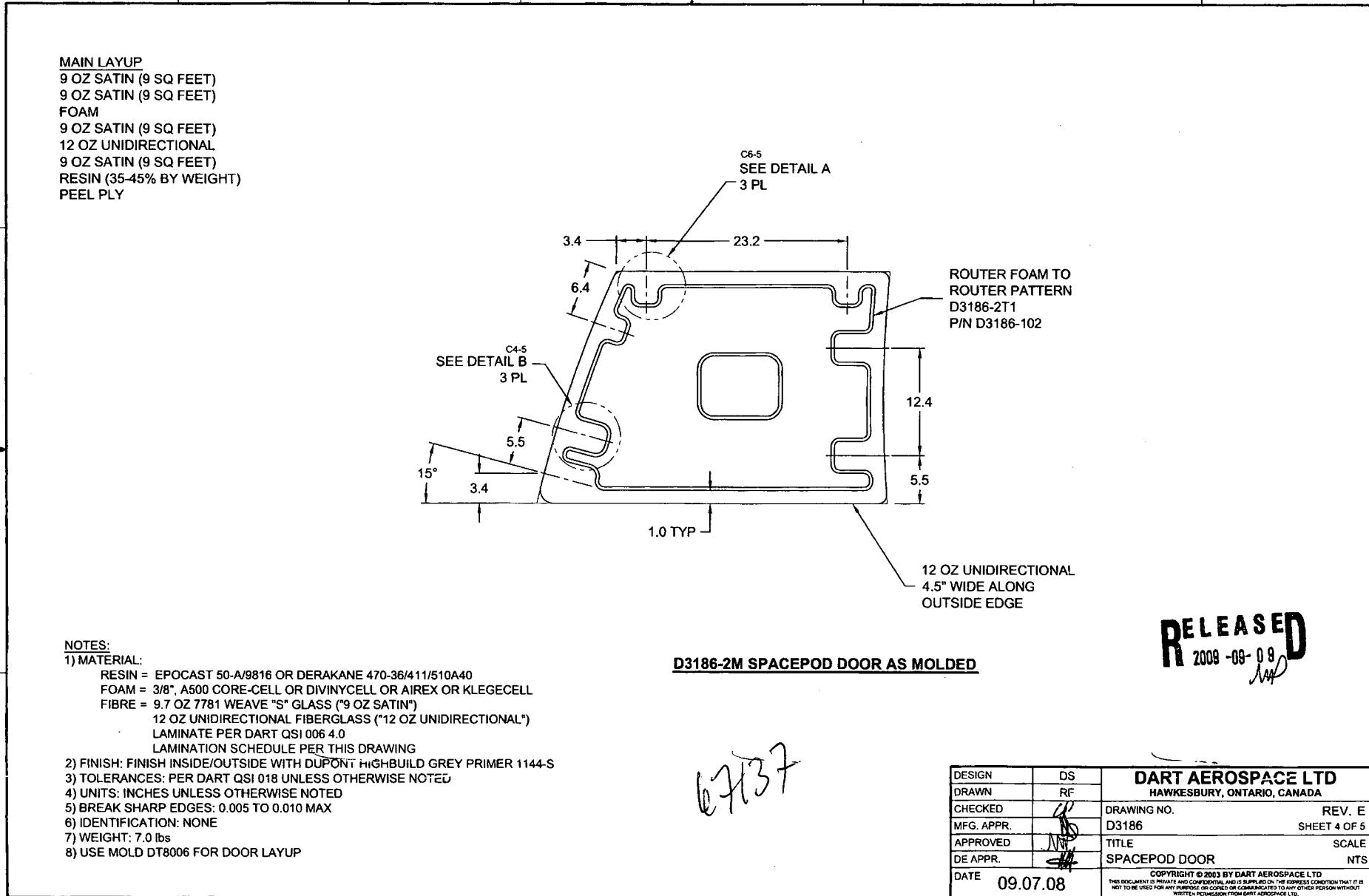
**MAIN LAYUP**  
 9 OZ SATIN (9 SQ FEET)  
 9 OZ SATIN (9 SQ FEET)  
 FOAM  
 9 OZ SATIN (9 SQ FEET)  
 12 OZ UNIDIRECTIONAL  
 9 OZ SATIN (9 SQ FEET)  
 RESIN (35-45% BY WEIGHT)  
 PEEL PLY

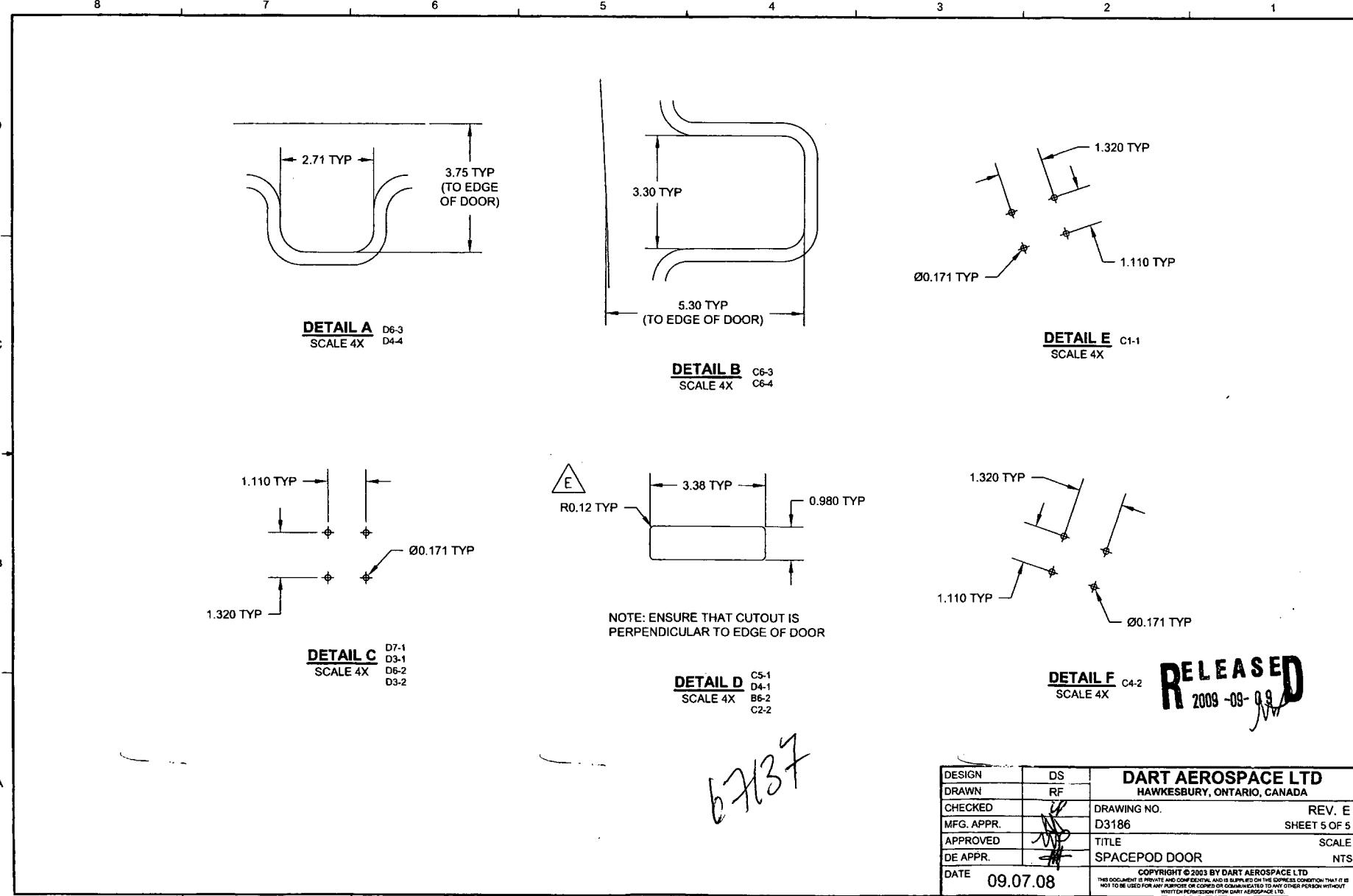
RELEASED  
 2008-08-08  
*6737*

DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CR</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>RD</i>	D3186	SHEET 3 OF 5
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2008 BY DART AEROSPACE LTD. THIS DOCUMENT IS NOT CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

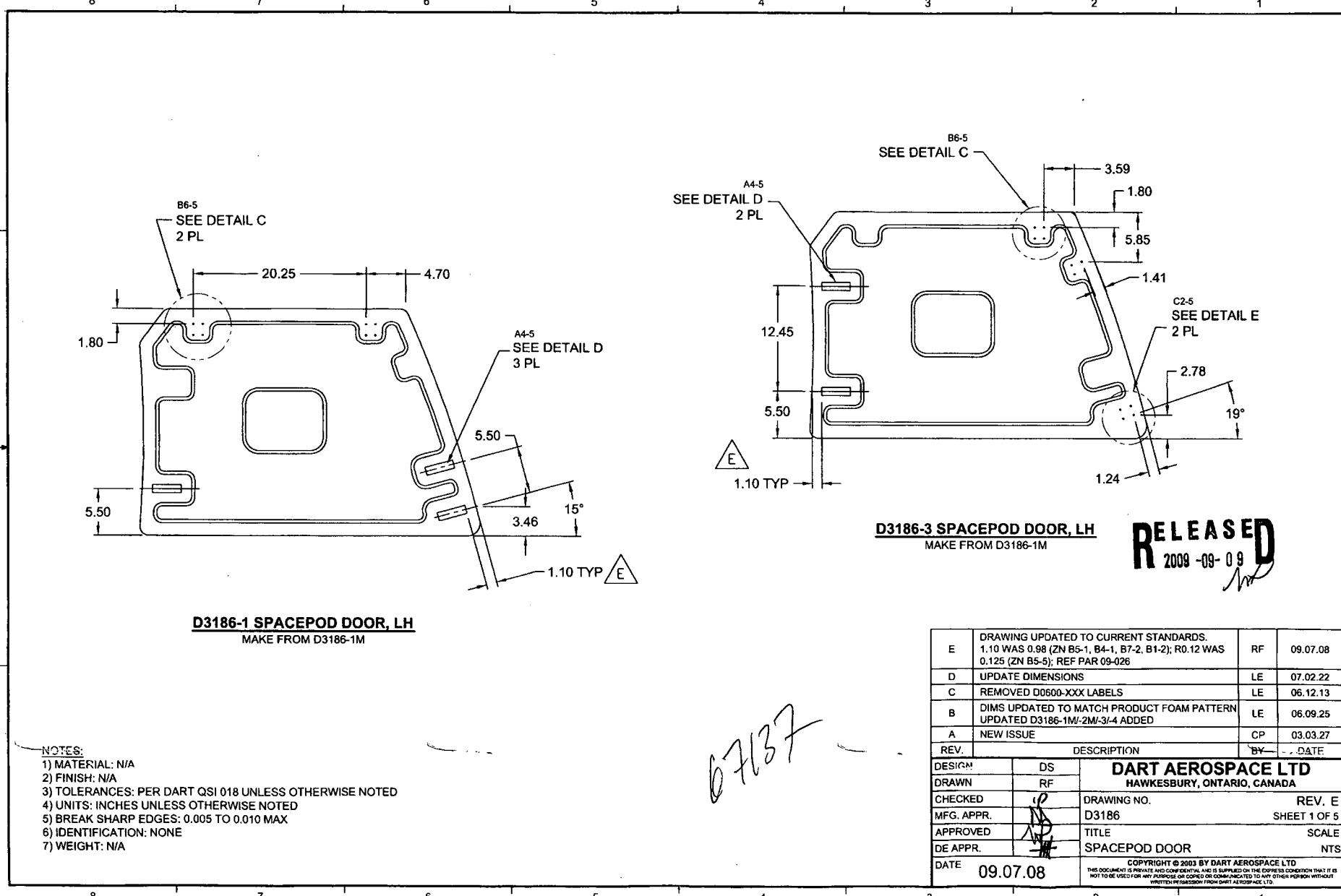
8 7 6 5 4 3 2 1





DESIGN	DS	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. E
MFG. APPR.	<i>[Signature]</i>	D3186	SHEET 5 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	SPACEPOD DOOR	NTS
DATE	09.07.08	COPYRIGHT © 2003 BY DART AEROSPACE LTD THIS DOCUMENT CONTAINS PROPRIETARY INFORMATION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

**RELEASED**  
2009-09-09



## **Linda Lacelle**

---

**From:** Carrie Pearson <carrie@darths.com>  
**Sent:** March 9, 2011 12:09 PM  
**To:** Linda Lacelle  
**Subject:** RE: D3186-4

Yes , that is what we want undrilled

---

**From:** Linda Lacelle [mailto:[llacelle@dartaero.com](mailto:llacelle@dartaero.com)]  
**Sent:** March 9, 2011 11:42 AM  
**To:** Carrie Pearson  
**Subject:** D3186-4  
**Importance:** High

Hi Carrie,

Could you find out if the customer will take the door without the holes for the hinges and latch? Since we cannot fit it to the customers spacepod body, the door cannot be trimmed, and we are unsure if the holes will line up properly to his spacepod body.

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd  
Hawkesbury, ON  
Phone: 613 632 9577  
Fax: 613 632 1053  
Cell: 613 676 1655

---

PLEASE NOTE OUR NEW CORPORATE OFFICE ADDRESS: 4650 North Avenue, Oceanside, California 92056

*Disclaimer* - This email and any files transmitted with it are confidential and may contain privileged or copyright information. You must not present this message to another party without gaining permission from the sender. If you are not the intended recipient you must not copy, distribute or use this email or the information contained in it for any purpose other than to notify us.

If you have received this message in error, please notify the sender immediately, and delete this email from your system. We do not guarantee that this material is free from viruses or any other defects although due care has been taken to minimize the risk.

Any views expressed in this message are those of the individual sender, except where the sender specifically states them to be the views of DART Helicopter Services.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries